

Date: Tuesday, 11/29/2005 4:30:13 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLATE
Job Number : 25022	
Estimate Number : 10642	
P.O. Number : N/A	Part Number : D31631 <sup>28</sup>
This Issue : 11/29/2005 S.O. No. : N/A	Drawing Number : D3163 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : B
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 12/6/2005
Checked & Approved By : <u>SEE COMMENT BELOW</u>	Qty: <u>6</u> Um: Each
Comment : Est. B 05.10.25 Remove Powder Coat KJ/RF	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 80000000189

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3163

Possible Supplier: GFI

Material release note is required

Batch # M12758

0511130 M2024738032  
 make by hand

FF 05.12.01

2.0	D31631F	Plate
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Comment: Qty.: 1.0000 U(s)/Unit Total: 2.0000 U(s)  
 Plate

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

N/A

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

John V. 31

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr

FF 05-12-01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/01/31  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PLATE

Job Number: 25022

Part Number: D31631

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06-01-25

6

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-01-25 6

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

GA

FF 06-01-30 6

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUC 06/02/17 (6) 06/01/31

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

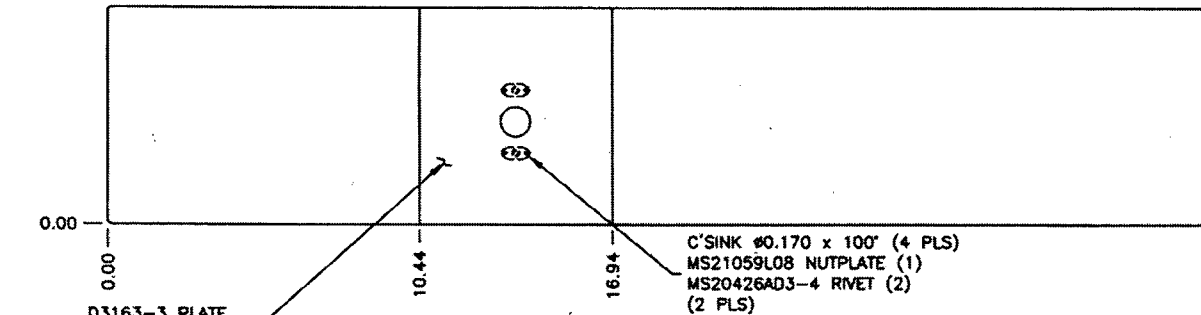
NOTE: Date & initial all entries

**DART**



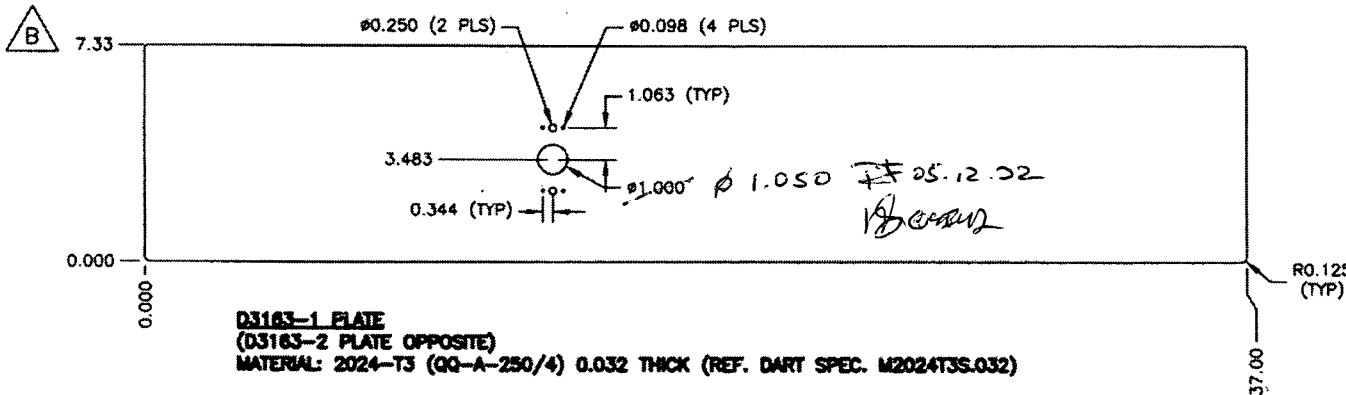
RELEASED  
04/11/23

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3163
DATE 04.10.06	02.04.26	TITLE PLATE
A	04.10.06	REV. B SHEET 1 OF 1
B	04.10.06	SCALE 1:6
		7.33 WAS 7:20; REMOVE PERIMETER HOLES

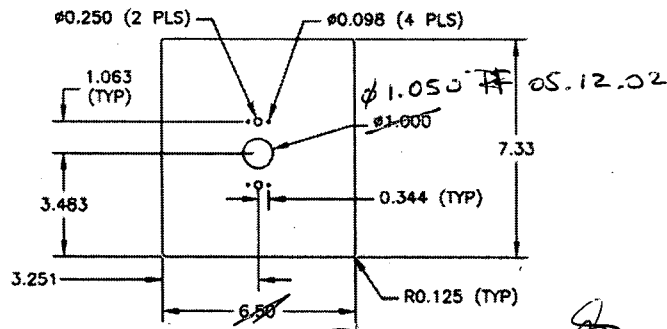


D3163-3 PLATE  
BOND TO D3163-1  
USING SIKAFLEX 241/291  
AHESIVE

**D3163-041 PLATE SHOWN POSSIBLE SUPPLIER: PREMIER P/N B30-23000-18**  
**(D3163-042 PLATE OPPOSITE POSSIBLE SUPPLIER: PREMIER P/N B30-23000-20)**



**D3163-1 PLATE**  
**(D3163-2 PLATE OPPOSITE)**  
**MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (REF. DART SPEC. M2024T3S.032)**



**D3163-3 PLATE**  
**MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)**

**GENERAL NOTES:**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) BREAK SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

**UNDER REVIEW**  
05.11.21  
05.12.02  
CANCEL